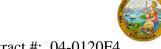
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-008810 Address: 333 Burma Road **Date Inspected:** 23-Aug-2009

City: Oakland, CA 94607

OSM Arrival Time: 1845 **Project Name:** SAS Superstructure **OSM Departure Time:** 715 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: N/A **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component: OBG** Fabrication

Summary of Items Observed:

CWI Inspectors: NA

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Bay 2

ZPMC issued "Inspection Notification Sheet" number 4046 informing Caltrans QA that ZPMC has completed ultrasonic inspections of the following OBG floor beam welds: FB3001-001-021, FB3001-001-50, FB3001-001-26, FB3086-001-23, FB3086-001-31, FB3086-001-26, FB3053-001-21, FB3053-001-50, FB3053-001-26, FB3038-001-023, FB3038-001-031, FB3038-001-026, FB3051-001-023, FB3051-001-050, FB3051-001-026, FB3055-001-021, FB3055-001-050, FB3055-001-026, FB3085-001-023, FB3085-001-03 and FB3085-001-026. This QA Inspector visually observed that floor beam FB3001-001-021 has a weld crown reinforcement of approximately 4 mm and AWS D1.5 indicates that the maximum allowable reinforcement is 3 mm. This QA inspector informed ZPMC CWI Mr. Li Zhi Jiang who concurred that this weld is visually rejectable and that he will have the weld crown ground to remove the excessive weld reinforcement. This QA Inspector later observed that ZPMC has ground the weld crown of FB3001-001-021 for a length of approximately two meters and that the weld crown reinforcement is now less than 3mm in height. This QA Inspector performed ultrasonic inspections of approximately 10 percent length on each of the welds listed above and items observed by

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on these inspections see the TL6027 Ultrasonic Test Report.

Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson, Paul	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer